








Work Order ID 71891

Wednesday, July 13, 2011 11:10:20 AM


Page 1


Item ID:	D2803-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Bracket				Stop	
Start Date:	7/14/2011	Start Qty: 8.00		Cust Item ID:		
Required Date:	7/28/2011	Req'd Qty: 8.00		Customer:		
Reference:						


Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-07-13</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2803	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet		0.00						<u>811-8-11</u>	
FLOW CNC Waterjet	Memo								
6061 1/2 X 10	1-Cut as per FILE D2803-1								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1		0.00						<u>8 11-8-11</u>	
HAAS CNC vertical machine #1	Memo								
	Machine as per folio FA102								

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00						<u>8</u>	
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

Accept

[illegible]**Setup Start**

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

QC8- Inspect parts - second check

0.00

SL 11-08-08

Abstract

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

[illegible]

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

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QC

Memo

0,00

Quality Control

8x Ø m / 1400 / 12

8th. 11-9-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71891

Wednesday, July 13, 2011 11:10:20 AM

Page 3

Item ID: D2803-1

Accept

Revision ID:

Item Name: Bracket

Start Date: 7/14/2011 Start Qty: 8.00

Required Date: 7/28/2011 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: S

0.00



Packaging

Memo

0.00

Packaging



SP 11-07-13

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/14

11-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 11:10:18 AM

Page 1

Work Order ID: 71891

Parent Item: D2803-1

Parent Item Name: Bracket



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A□00.11.06□New Issue□EC□
IPP Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM
IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased	No			100	f	39.1249	1.9167	16.14063	16.		



6061-T6 Bar .500 x 10.00



811-8-11

Location

MAT004

111382

118271

118400

Loc Qty

39.1249

3

36.1249

Loc Code

111382 x4

118400 x4

8

6061 T6 BAR .500 X 12"

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 71891
Description: Bracket		Part Number: D2803-1
Inspection Dwg: D2803	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø.761	—		Vern ML-06	
Ø0.191	+0.005/-0.000	Ø.193	—			
Ø0.507	+0.000/-0.001	Ø.5066	—		Micr ML-07	
13.558	+/-0.010	13.558	—		M-type ML-04	
Ø0.507	+0.000/-0.001	Ø.507	—		Micr ML-07	
12.411	+/-0.010	12.411	—		M-type ML-04	
2.654	+0.000/-0.001	2.654	—		Vern ML-06	
0.437	+0.000/-0.001	.436	—		"	
1.420	+/-0.001	1.419	—		"	
6.933	+/-0.010	6.934	—		Vern cal-02	
0.250	+/-0.010	.249	—		Vern ML-06	
0.875	+0.000/-0.001	.875	—		Micr ML-07	
0.250	+0.000/-0.005	.248	—		Dim ML-05	
0.125	+/-0.010	.125	—		Vern ML-06	
0.125	+/-0.010	.128	—		"	
0.125	+/-0.010	.128	—		"	
0.125	+/-0.010	.128	—		"	
0.500	+/-0.010	.500	—		"	
0.562	+/-0.010	.562	—		"	
0.188	+/-0.010	.187	—		"	

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11/09/08	Date: 11-09-08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM [Signature]	[Signature]

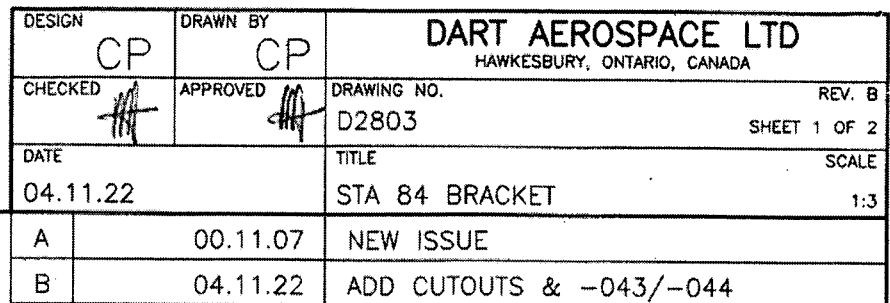
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

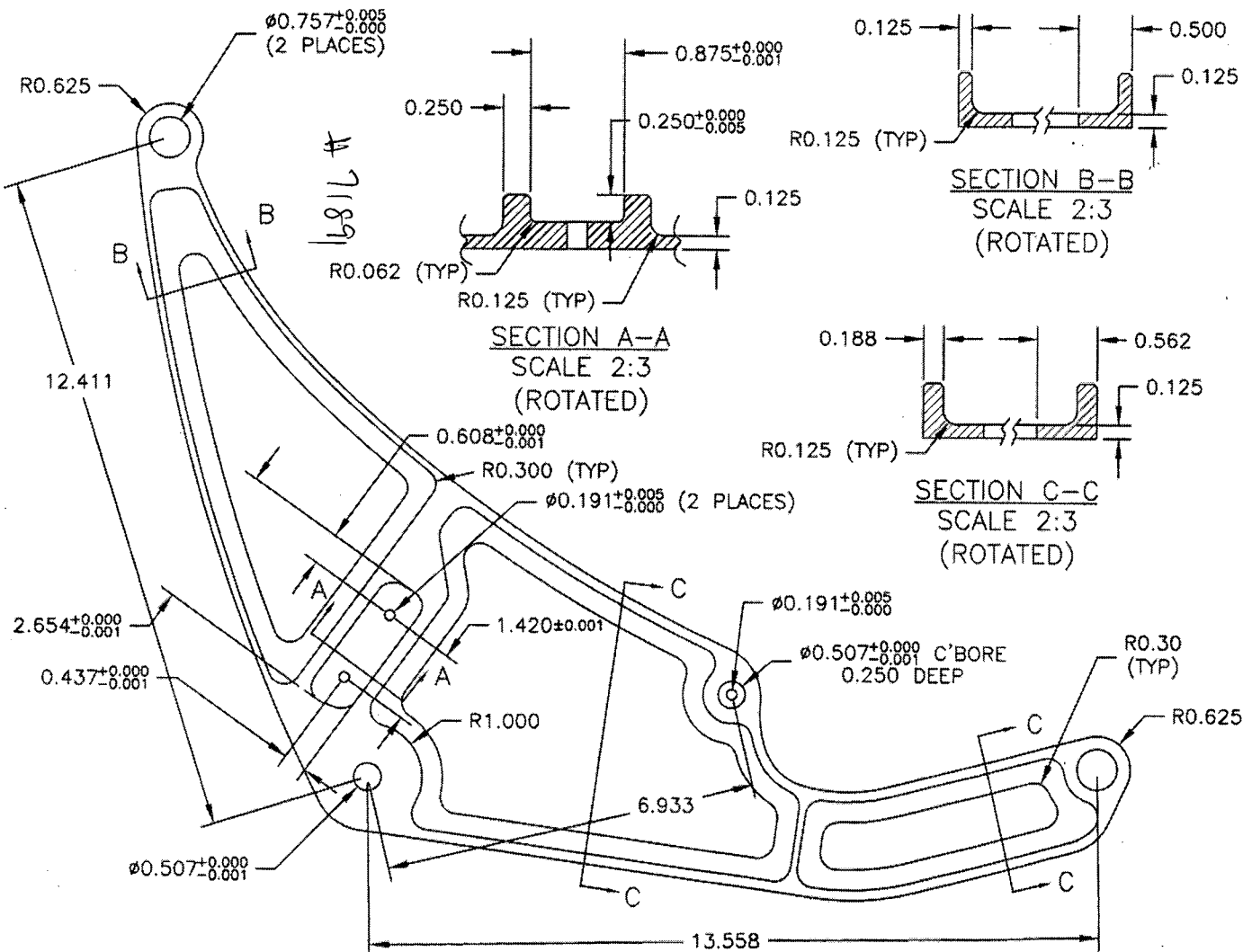
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



05.03.11



- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

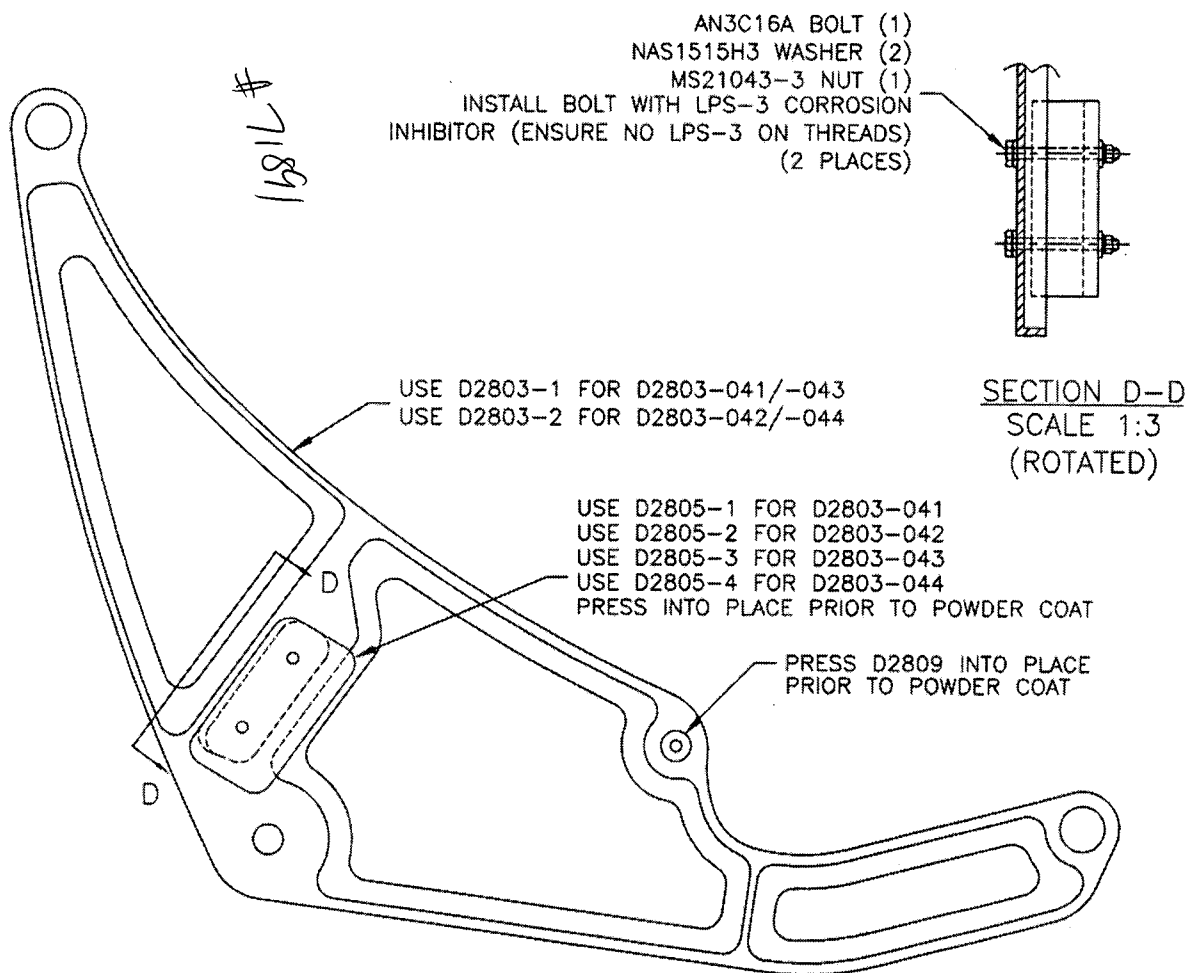
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803
				REV. B
DATE	04.11.22	TITLE	STA 84 BRACKET	SHEET 2 OF 2
				SCALE 1:3



RELEASED

05.03.11 *[Signature]*

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries